

# Work Order ID 56649

March 3, 2010 1:12:28 PM



Page 1

Item ID: D3546-1

Revision ID:

Item Name: Clip

Start Date: 03/03/2010 Start Qty: 6.00

Required Date: 08/03/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-3-03

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3546

Rev A

100



Waterjet

FLOW CNC Waterjet

304, 0.00

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3546 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

MAT NOT PULLED

10-3-9

18

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10-3-9

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sw/02/10

18

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3546

0.00

0.00

0.00

0.00

0.00

SO 10/03/11

Solo 14

N/A

13

8

418

PTO

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:



W/O: 56649

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.03.17	150	drag reads finish: done permanent change	Remove step 150 160	10.03.24		u 10.03.24	

Part No: D3546-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

**Work Order ID 56649**

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Item ID: D3546-1

Accept



Setup Start



Revision ID:

Item Name: Clip

Stop



Start Date: 03/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 08/03/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: ST245

0.00

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

18x

10-3-18

SP

10/03/24

CZ10/31/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

March 3, 2010 1:12:33 PM

Page 1

Work Order ID: 56649

Parent Item: D3546-1

Parent Item Name: Clip

Comments: IPP Rev:A New Issue 06-09-27 JLM

Start Date: 03/03/2010

Required Date: 08/03/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	225.4922	1.3263			

M304S18GA



304/316 .050 Sheet



B 10-3-9

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

108156

111743

112885

113062

112178

225.4921632

0.98526316

23.7174

72.7895

128

112178

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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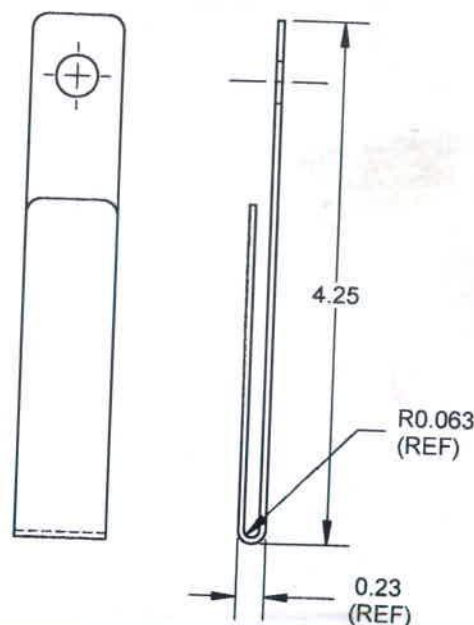
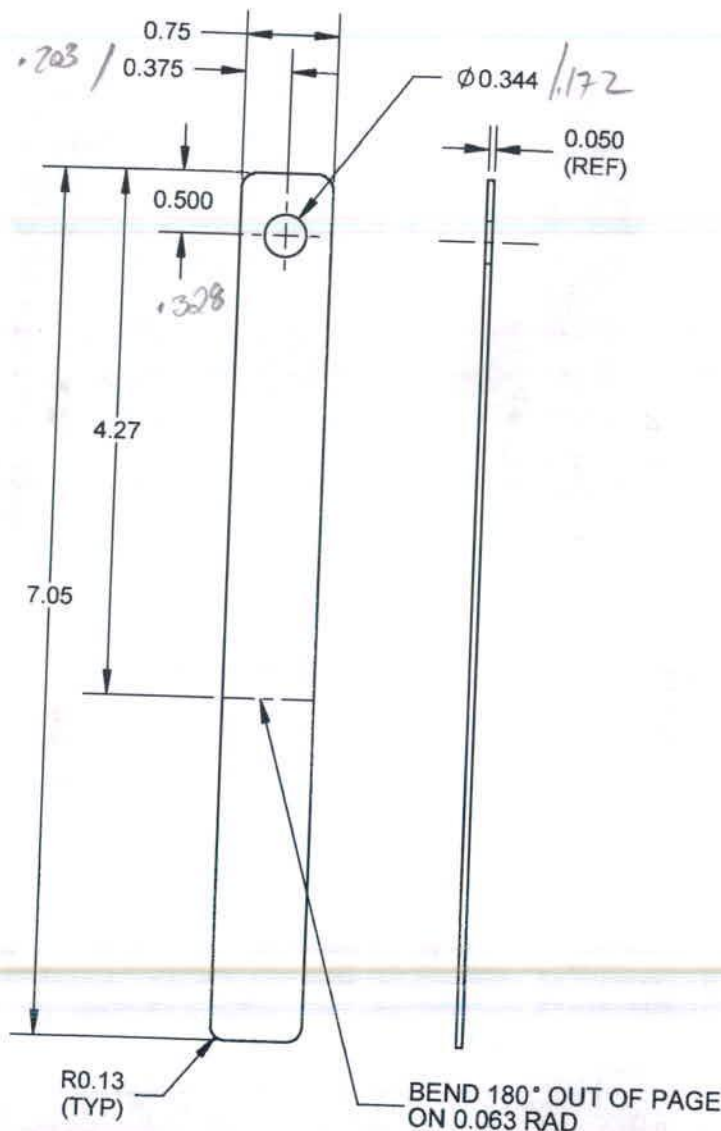
**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 36649  
BS10-3-03

DESIGN <u>LE</u>	DRAWN BY <u>LE</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <u>qp</u>	APPROVED <u>[Signature]</u>	DRAWING NO. D3546	REV. A
DATE 06.09.15		TITLE CLIP	SHEET 1 OF 1
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	SCALE 1:1



**D3546-1 CLIP**

**D3546-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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